

Work Order ID 137587

October 07, 2015 12:01:33 PM

137587

2 for OFFSHORE

2 for STOCK

Page 1

Item ID: D206-628-033

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 407

Start Date: 10/7/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/28/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

SK

Date 10/15/2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and type labels as per PPP D206-628-033 CHG 003

MCS

2

DAS

38

9-89

15-11-11

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2 (4)

DAS

6

9-89

DAS

28

9-89

NOV 11 2015

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

2

DAS

38

9-89

15-11-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Page 2

Item ID: D206-628-033

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 407

Start Date: 10/7/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/28/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00				2X	DAS 28		NOV 11 2015
Packaging	Identify and pack for shipping as per PPP D206-628-033						9-89		
	Location: _____								
	PPP Rev: <u>FG081</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

MW NOV 12 2015

MW NOV 12 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY							
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Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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137587

D206-628-033

Required Date: 10/28/2015

Required Qty: 4.00

Comments:	IPP Rev:D	As Per	EcN 766	06-01-06	JLM	
	IPP Rev:E	as per	ecN 1118	08-02-05	DD	verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No			110	Each	466.0000	3	12			
AN3C4A	DAS 38 9-89								**	131400 X 6			DAS 28 9-89
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				20					
				122814				20					
				FP001				111					
				M132551				61					
				M132803				50					
				ST349				142					
				M133234				142					
				ST350				193					
				M132317				193					
AN4C14A		Purchased	No			110	Each	36.0000	8	32			
AN4C14A	DAS 38 9-89								**	131452 X 8			DAS 28 9-89
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				25					
				118706				20					
				123021				5					
				ST344				11					
				m132767				11					

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Parent Item: D206-628-033

D206-628-033

Parent Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 407

Start Date: 10/7/2015

Required Date: 10/28/2015

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Purchased No

110 Each 64.0000 4 16

AN4C15A

Bolt

DAS
38
9-89

**

131377 X 8

DAS
6 28
9-89-89

Location	Loc Qty	Loc Code
FG	10	
120360	10	
ST312A	40	
M132763	20	
M132823	20	
ST343	14	
M132680	14	

D2731-3

Manufactured No

110 Each 49.0000 4 16

D2731-3

Mounting Lug

DAS
38
9-89

**

DAS
6 28
9-89 9-89

Location	Loc Qty	Loc Code
ST520	45	
123541	1	
132000	4	
134672	40	
ST538	4	
126661	4	

4
12 X 8

D2732

Manufactured No

110 f 312.1344 2 8

D2732

Rubber Cushion (\$per foot)

DAS
38
9-89

**

DAS
6 28
9-89 9-89

Location	Loc Qty	Loc Code
ST412	312.1344199	
117118	312.13442	

8

8 x D2732-030

D2842-041

Manufactured No

110 Each 0.0000 1 4

D2842-041

Step Assembly, 206 Float

DAS
38
9-89

**

624131 X 2

DAS
6 28
9-89 9-89

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Work Order ID: 137587

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Parent Item: D206-628-033

D206-628-033

Parent Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 407

Start Date: 10/7/2015

Required Date: 10/28/2015

Start Qty: 4.00

Required Qty: 4.00

D2844-1 Manufactured No

110 Each 10.0000 2 8

D2844-1

DAS
38
9-89

**

125358

DAS
28
9-89

Arm

Location

Loc Qty

Loc Code

ST352

10

132274

10

D2844-3

Manufactured No

110 Each 5.0000

D2844-3

DAS
38
9-89

**

125358

DAS
28
9-89

Arm

Location

Loc Qty

Loc Code

ST352

5

125162

3

129577

2

D3394-041

Manufactured No

110 Each 48.0000 4 16

D3394-041

DAS
38
9-89

**

13781021

DAS
28
9-89

Lug

Location

Loc Qty

Loc Code

ST523

20

134676

20

ST528

24

129578

5

134002

8

134676

10

134982

1

ST538

4

126662

4

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Work Order ID: 137587

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Parent Item: D206-628-033

D206-628-033

Parent Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 407

Start Date: 10/7/2015

Required Date: 10/28/2015

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

110

Each

1,114.000

12

48

MS21043-4

Nut

DAS
38
9-89

**

128798x30

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK004

300

m133316

300

CCK007

300

m132803

300

FG

40

104603

40

GA

101

m128798

101

ST304

373

m128818

39

m131697

9

m132382

4

m133031

171

m133134

150

NAS1149C0363R

Purchased

No

110

Each

1,133.000

3

12

NAS1149C0363R

Washer

DAS
38
9-89

**

Location

Loc Qty

Loc Code

FP001

60

114742

60

GA

506

m133077

506

ST260a

494

m133077

494

ST271

73

m130673

20

m132763

53

DAS
6
9-89

DAS
28
9-89

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Work Order ID: 137587

137587

Parent Item: D206-628-033

D206-628-033

Parent Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 407

Start Date: 10/7/2015

Required Date: 10/28/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

110

Each

1,116.000

24

96

NAS1149C0432R

WASHER

DAS
38
9-89

**

131452
12/8

DAS
6
9-89
DAS
28
9-89

Location

Loc Qty

Loc Code

GA

889

m125807

428

m131467

461

ST271

227

m131467

227

NAS1515H3

Purchased

No

110

Each

378.0000

3

12

NAS1515H3

Washer

DAS
38
9-89

**

Location

Loc Qty

Loc Code

FG

10

123301

10

GA

38

m129521

38

ST266

330

m128635

7

m131697

323

NAS1515H4L

Purchased

No

110

Each

183.0000

24

96

***NAS1515H4L ***

Washer

DAS
38
9-89

**

130466 X11

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

22

103691

2

m132189

20

ST266

161

m132189

44

m132767

117

131624 X32

DAS
28
9-89

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Page 1

Customer:

Stop *NR2*

[illegible]

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-628

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5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*LUG
4	4			8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*LUG
8	8	8	8			*MS35489-93	*GROMMET
1	1					D4064-041	MOUNTING LUG
1	1					*D4064-1	*LUG
2	2					*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	NAS1149C0363R	WASHER (OR AN960C10)
16	16					NAS1149C0463R	WASHER (OR AN960C416)
8	8	24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

5.3 QUICK RELEASE PIP PIN KIT

Qty -011	Part Number	Description
X	DSI9235-011	QUICK RELEASE PIP PIN KIT
4	BLRS-020	QUICK RELEASE PIN

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Revision: **G**

Date: 11.02.25